

## PA66 | KEPAMID 2333GFH | 玻纤增强牌号

- KEPAMID 2333GFH是玻纤33%增强的耐热性PA66牌号。
- 具有高刚性和高温下长期热稳定性
- 适用于汽车、电子电气和工业中的部件

| 物理性能                                                     | 测试标准       | 单位 | 数值        |
|----------------------------------------------------------|------------|----|-----------|
| 填充比例                                                     | ISO 1172   | %  | 33        |
| 比重                                                       | ISO 1183   | -  | 1.39      |
| 吸水率(23 °C, 50 % RH)                                      | ISO 62     | %  | 0.7       |
| 收缩率(流动方向, $\Phi = 100 \text{ mm}$ , $t = 3 \text{ mm}$ ) | KEP Method | %  | 0.5 ~ 0.8 |

| 机械性能          | 测试标准     | 单位                | 数值   |
|---------------|----------|-------------------|------|
| 拉伸强度          | ISO 527  | MPa               | 195  |
| 断裂伸长率         | ISO 527  | %                 | 3.0  |
| 弯曲强度          | ISO 178  | MPa               | 285  |
| 弯曲模量          | ISO 178  | MPa               | 9850 |
| 简支梁缺口冲击强度     | ISO 179  | kJ/m <sup>2</sup> | 10   |
| 洛氏硬度(R-scale) | ISO 2039 | -                 | 121  |

| 热性能                         | 测试标准      | 单位    | 数值  |
|-----------------------------|-----------|-------|-----|
| 熔点(10 °C/min)               | ISO 11357 | °C    | 260 |
| 热变形温度(0.45 MPa)             | ISO 75    | °C    | 260 |
| 热变形温度(1.8 MPa)              | ISO 75    | °C    | 255 |
| 燃烧性( $t = 0.8 \text{ mm}$ ) | UL 94     | Class | HB  |

| 电性能          | 测试标准      | 单位                       | 数值        |
|--------------|-----------|--------------------------|-----------|
| 介电常数 (1 MHz) | IEC 60250 | -                        | 3.7       |
| 体积电阻率        | IEC 60093 | $\Omega \cdot \text{cm}$ | $10^{15}$ |

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## 注塑条件



### 预干燥 (建议最大吸水率为: 0.05 %)

推荐干燥条件: 80 °C, 4 ~ 6 h, 除湿干燥机

推荐干燥条件: 90 °C, 6 ~ 8 h, 热风干燥机

### 温度

模具温度: 70°C ~ 90 °C

料筒温度: 280°C ~ 290 °C

| 模具         | Bn (喷嘴) | B3 (计量) | B2 (压缩) | B1 (喂料) | 料斗         |
|------------|---------|---------|---------|---------|------------|
| 70 ~ 90 °C | 290 °C  | 285 °C  | 285 °C  | 280 °C  | 60 ~ 80 °C |

### 塑化

螺杆转速: 80 ~ 120 rpm

背压: 5 ~ 10 kgf/cm<sup>2</sup>

### 联系方式

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